

EFFICIENCY SQUARE END MILLS SERIES

ELD



DEPTH OF CUT



Long Flute / Square End Mills

unit: mm

Order No.	Diameter D1	Flute Length L1	O.A.L. L2	Shank Dia D2
ELD 0204	2.0	15	50	4
ELD 0304	3.0	20	50	4
ELD 0404	4.0	25	75	4
ELD 0506	5.0	30	75	6
ELD 0606	6.0	30	75	6
ELD 0808	8.0	40	100	8
ELD 1010	10.0	40	100	10
ELD 1212	12.0	45	100	12
ELD 1616	16.0	60	150	16
ELD 2020	20.0	60	150	20



Recommended cutting condition for ELD

MATERIAL	Carbon Steels . Alloy Steels S45C, FC, FCD, SCM, SS0C, SKS...		Alloy Steels . Tool Steels SCr, SNCM, SKD11, SKD61, NAK80...		Hardened Steels SKD11	
	HARDNESS ~HRC30		~HRC50		~HRC60	
DIAMETER	SPEED (mm ⁻¹)	FEED mm / min	SPEED (mm ⁻¹)	FEED mm / min	SPEED (mm ⁻¹)	FEED mm / min
2	3000	50	2500	40	1000	15
3	2500	60	2000	50	800	20
4	2000	80	1700	70	700	30
5	1800	110	1500	85	600	40
6	1500	110	1400	75	550	50
8	1300	110	1100	75	450	50
10	1000	110	800	75	300	50
12	900	110	700	75	250	40
16	800	95	500	70	150	20
20	500	80	400	60	120	20